Work Orde April-22-13 1:3		00421		*100	1421*						Page 1
Item ID: Revision ID: Item Name:	D3912-5 Eyebolt Plate		,	Accept	*N900	040	100)* s	etup Star Sto	I ZI	S1* S2*
Start Date: Required Date: Reference:	4/22/13 : 5/03/13	Start Qty: 20.0 Req'd Qty: 20.0	, , ,		Cust Item 1 Customer:	ID:	·				
Approvals:		an: MUJ	Date: \\\ \\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	Tooling: SPC (Y/N):		ate:		R	un Stai Sto	" []	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D3912	В										·
*100 *100* Waterjet FLOW CNC Waterj	iet	Prog Rev Dwg Rev		0.00				20	0		JM13-4-27
*110 *110*		QC2- Inspect parts of	f machine FAI/FAIB	0.00				2 ಬ	_ 0		Jm13-4-2

Memo

Quality Control

											DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	er.		1			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	. Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	·····		 .		. ,	<u>-</u>	AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection	Crimped t n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in l	Extrusio	n	Drawing	1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order ID April-22-13 1:39:59 Pi			*1004	121*				Page 2
Item ID: D3912 Revision ID: Item Name: Eyebolt			Accept	*N90004	L 0100)* s	Setup Start Stop	*NS1*
Start Date: 4/22/13 Required Date: 5/03/13 Reference:	3 Start Qty: 20.00	*20* *20*		Cust Item ID: Customer:		·		14.57
Approvals: Proce	ess Plan:	Date:	Tooling: SPC (Y/N):	Date:	,	F	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 120 *120* QC Quality Control	Operation Description QC8- Inspect parts - seco	ond check	Set Up/ Run Hours 0.00 0.00		ol# Plan Code	Accept Qty		Reject Insp. Number Stamp
*130 *130* Packaging Packaging	' Identify as per dwg & Sto	ock Location:	0.00				43/4	1/12 30
140 *140* QC Quality Control	QC21- Final Inspection -	- Work Order Release	0.00				/:	3/5/6 H)

13-4-29

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Closed:	Date:	

										QA Closed:	Da	te:
Work Orde	er:		. <u>-</u>		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No.				Rework Scrap Use-as-is Work Order Update] т	herm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root		1		Descri	iption of work order update	Init	ial	Ac	ction	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief	Eng	Desc	cription	Date	Verificatio	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				·								
опаррточец	<u> </u>		1	<u> </u>	F.	AULT C	:ATE	GORY		<u> </u>	I	
Landi	ng Gear				General							
	Bending Centre N Cracks Crushed Cuffs Heat Tre Inspecti Ripples Torque Turning	Vot Conce /Crimped eat on Strip in in Bend Waves in I Sequence	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Ha Ins	struction ainteristate is laber is read if set of Court of S	on Incomplete ions Incomplete/ nance led Calibration Gequence	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Wave/T	wist in Tu	be		Folio	Ou	ıtside	Dimensions				•

Picklist Print

April-22-13 1:39:59 PM

Work Order ID:

100421

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

Start Date: 4/22/13

Required Date: 5/03/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 904/316 0.125 Sheet		Purchased	No			100	sf	199.0300	0.05125	1,07 8948			J M13.4
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		199.03			-				
				1225	521	24.93							
				1244	145	174.1			13/1/	445			

ð

NCR: Ye	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Order	-				DISPOSITION				AGAINST DE	PARTMENT		
Part No	D			· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR No	o				Work Order Update	<u> </u>		Large Fab	Composite	necy stol	Supplier	
Root				Descri	iption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data												
perator												
/laterial				,								
etup												
Other					•							
rocess	-		,	·								
upplier		Ì				1						
raining				ł			:					·
Inapproved												
					F.	AULT	CATE	GORY				
Landin	g Gear				General	_				1		.
	Bending				Bend	ШG	rain	•		Ovalized		Pressure/Forced
. [Centre No	ot Conce	ntric to	o/s	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure
Ĺ	Cracks				Broken/Damaged	lin	rspecti	on Incomplete		Part Incorre	⊢	Weld
	Crushed/	Crimped			Burrs	∐ In	struct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Шм	/lainte	nance		Part Moved		
	Heat Trea	at			Countersink	Шм	1islabe	led		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short	\square M	lisreac	i		Power Loss/	Surge	Other
Γ.	Ripples in	Bend			Drill Holes	□ o	ffset					
	Torque W	/aves in E	Extrusio	n [Drawing	o	ut of (Calibration				
	Turning S	equence			Finish	o	ut of S	Sequence				·
·	Wave/Tw	ist in Tul	ре		Folio	По	utside	Dimensions				

DQA: Date:

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	124001
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

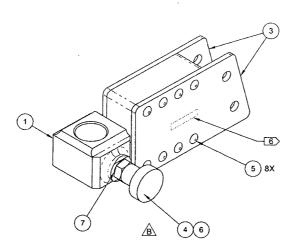
FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	-		V	Jhnoi
Ø0.257	+0.006-0.001	O.257"			V .	
0.38	+/-0.030	0.379"	_		v	
1.500	+/-0.010	1.503"	-		V .	
0.500 Pitch	+/-0.010	0,504"	_		ν	
3.15	+/-0.030	Ø 3.15"			· V	
0.375	+/-0.010	0.379			ν	
0.517	+/-0.010	0.524"	-		·V	
1.000	+/-0.010	1.001"	_		V	
3.65	+/-0.030	3.65	-		V	·
1.500	+0.020/-0.000)		v	
0.25	+/-0.030	1.504°	~		V	
2.00	+/-0.030	2013"	_		×	
0.125	+/-0.010	0.118"	_		V	
					13.	` .
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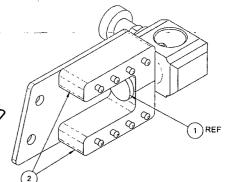
			OAn'		
Measured by: Jm		Audited by:		Preliminary Approval:	·
Date: 13-	4-27	Date:	13.429	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ 1	
В	10.08.09	Dwg Rev updated	KJ O	
			· '7)	/363

:	ITEM	QTY -041	! P/N	DESCRIPTION	i
		Х	D3912-041	EYEBOLT RECEIVER ASSY	
		_ 1	D3912-1	EYEBOLT	
	2	2	D3912-3	EYEBOLT BLOCK	7
	3!	2	D3912-5	EYEBOLT PLATE	
D	4	11	D3801-1	SPRING PLUNGER	B
	- 5	8.	MS20615-4M20	RIVET -	7
	6	1	MS21209-F615	HELICAL	1 ,
	7	1	NAS1149F0332P	WASHER	(B)



100421 MLJ 13-04-23



SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

С

D3912-041 EYEBOLT RECEIVER ASSY

С

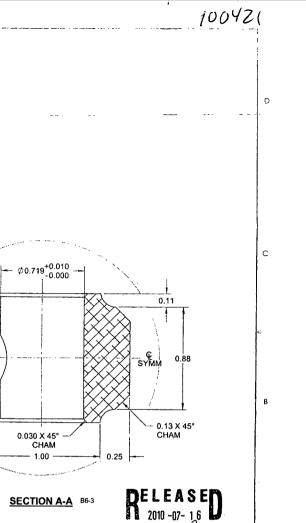
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT-INK MARKER
7) WEIGHT -041: 1.58 lbs

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. JPH 10.06.28 NEW ISSUE Α JPH 10.03.04 REV. DESCRIPTION BY DATE

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY DE APPR. NTS DATE

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8



D3912-1 EYEBOLT

B2-3 A

2.23

R0.13 --

0.90 REF

0.13 X 45° CHAM 4 PL

R0.015

--- 1 20 ------ 0.625 --- -

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT: 0.45 lbs

0.13 - --

Ø0.700 Ø0.500

€ SYMM

8

D

С

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED D3912 MFG. APPR. APPROVED TITLE EYEBOLT RECEIVER ASSY DE APPR. DATE 10.06.28

1.72

0.75 REF 0.970

0.22

0.44

1.100

- 0.13 X 45°

CHAM

Ø0.650

B

R0.13

TYP

DRILL & TAP 3/8-24 FOR

MS21209-F615 HELICAL INSERT

R0.13

B Ø2.00 STOCK

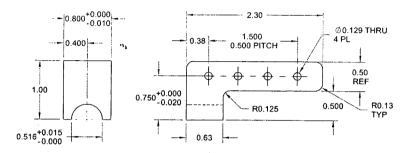
REF

SHEET 2 OF 3

SCALE

REV. B

1.00



D3912-3 EYEBOLT BLOCK

1.500 0.500 PITCH 10.375 R0.13 TYP - 0.38 0.25 0.517 1.000 1.500+0.020 2.00 REF Ø0.129 Ø0.257 8 PL 0.125 2 PL REF 3.65 3.69 REF

D3912-5 EYEBOLT PLATE

93 -	
8 6. /	LEASE 2010 -07- 1 6
	Q _m x

	DESIGN	ASS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	#1		
,	CHECKED	-An	DRAWING NO.	REV. B
	MFG, APPR,	Quil	D3912 _{SHEE}	ET 3 OF 3
	APPROVED	149	TITLE	SCALE
	DE APPR.	-#	EYEBOLT RECEIVER ASSY	NTS
	DATE 10.06.28		COPYRIGHT © 2010 BY DART AEROSPACE LTD 193 DOLLEGIT STRONG HE DOMODROUN AND IS EXPENDED ON DRE DIFFERS TO DOMOTON THAT IT IS NOT TO BE USED FOR MAY PAIROSE OR COPED OR COMMARCATED TO MAY OTHER PRISON WITHOUT THIS PROMISSION PROMISSION OF THE DESCRIPTION OF THE PRISON WITHOUT THIS PROMISSION PROMISSION OF THE DESCRIPTION OF THE PRISON WITHOUT THE PRISON OF THE PRISON OF THE PRISON DATE OF THE PRISON OF THE PRISON WITHOUT THE PRISON OF THE PR	

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

8

С

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs